

Work Order ID 163426

Tuesday, June 27, 2017 12:09:42 PM

163426

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Item ID: D5344-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bell Medium Main Rotor Tie Down - Tie Down Assembly
Start Date: 6/27/2017 Start Qty: 2.00 *2* Cust Item ID:
Required Date: 7/7/2017 Req'd Qty: 2.00 *2* Customer:
Reference:

Approvals: Process Plan: DAS 21 Date: JUL 03 2017 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5344	REV A

100 Pick Kit

0.00

100

Packaging

Memo

0.00

Packaging

110

0.00

110

Small Fab

Memo

0.89

Small Fab

1- CUT TWO HOLES IN BALL AS PER NOTE 8 (Use DT10301 jig and DT10301A custom hole saw) Locate fixture with 1/2" dowel pin then clamp down fixture on table.

2- ASSEMBLE AS PER NOTE 8,9 AND 10

SEP 20 2017

DAS
9-89

163426

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause			FAULT CATEGORY							
Environment ☐	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong
Design ☐	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions
Doc/Data ☐	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance
Equip/Tooling ☐	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect
Handling/Pre ☐	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing
Material ☐	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved
Internal Transport ☐	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing
Tribal Knowledge ☐	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish
LOA ☐	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread
Substation ☐	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence
Past Expiry Date ☐	☐	Manufacturing Process	OTHER :							
Misidentified ☐	☐	Past Due								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									



SEP 20 2017

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Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Work Order ID: 163426

163426

Parent Item: D5344-041

D5344-041

Parent Item Name: Bell Medium Main Rotor Tie Down - Tie Down Assembly

Start Date: 6/27/2017

Required Date: 7/7/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 16.06.06 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D5339-1 *D5339-1* Carabiner Clip		Manufactured	No			110	Each	50.0000	1	2		SEP 19 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST164				50					
					152013			50					
D5340-1 *D5340-1* Tennis Ball		Manufactured	No			110	Each	85.0000	1	2		SEP 19 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST443				85					
					147201			85					
D5341-1 *D5341-1* Nylon Rope		Manufactured	No			110	f	174.0000	18	36		SEP 19 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST443				174					
					155234			174					
D5342-1 *D5342-1* Rope Clamp		Manufactured	No			110	Each	13.0000	1	2		SEP 19 2017	DAS 6 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST443				13					
					147866			13					

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Misidentified ☐	Past Due ☐																																																																

Picklist Print

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Work Order ID: 163426

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Parent Item: D5344-041

D5344-041

Parent Item Name: Bell Medium Main Rotor Tie Down - Tie Down Assembly

Start Date: 6/27/2017

Required Date: 7/7/2017

Start Qty: 2.00

Required Qty: 2.00

D5343-1

Manufactured

No

110

Each

26.0000

1

2

D5343-1

Long Hook

**

DAS

SEP 19 2017

Location

Loc Qty

Loc Code

DT443

5

147204

5

ST443

21

147888

21

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Shop Packet Print

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Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval		
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OTHER : _____									